

Date: 10/09/2008 3:46:14 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STUB COVER
Job Number	: 41956		
Estimate Number	: 12415		
P.O. Number	:	Part Number	: D34941
This Issue	: 10/09/2008 S.O. No. :	Drawing Number	: D3494 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL / MED FAB	Drawing Revision	: B
Previous Run	: 38900	Material	:
Written By	:	Due Date	: 30/09/2008 Qty: 10 Um: Each
Checked & Approved By	: <u>JUL 08.9.11</u>		
Comment	: Est Rev:A New Issue 06-05-18 JLM est rev B ecn 888 06.12.13 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 Sheet .063
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Comment: Qty.: 0.6972 sf(s)/Unit Total : 6.9720 sf(s)
 304/316 .063 Sheet
 (M304S16GA)
 Batch: 108724 HB 8-9-11

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3494
 Dwg Rev: B
 Prog Rev: B

HB 8-9-11

2-Deburr if necessary

HB 8-9-11

12

P10

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HB 8-9-11

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

Socloris 15 (12)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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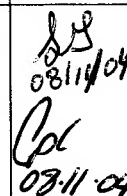

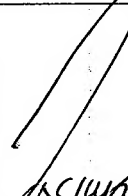


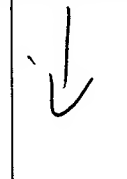


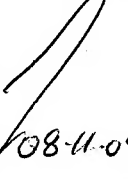


Comment: SMALL & MEDIUM FAB RESOURCE 1
 Form as per Dwg D3494

SP 08/10/02 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3494-1 PAR #: N/A Fault Category: Prod - ^{Sm FFB} WARE NCR: Yes No DQA: 1A Date: 08.11.11
 (D350-616-015) Resolution: Re-work Disposition: Re-work QA: N/C Closed: 1A Date: 08/11/11

NCR: <u>41956</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/11/5	20	two (2) parts found with cut out parts parts were placed too close together the 2 parts were		cut out will be filled with weld ^{wept} & Duncan welding.	 08/11/04 Coc 08/11/04	 08/11/04		
		cut on water jet R.C. Cut in on w.s. intended between the 2 parts. Too close together. Inherent process blow-outs repaired			 ↓ 08-11-04	 08-11-04		 08-11-04

NOTE: Date & initial all entries

Date: Wednesday, 10/09/2008 3:46:14 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STUB COVER

Job Number: 41956

Part Number: D34941

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

508/10/03 (42)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Dwg D3494

A/R SS ROD Batch:

*see (ph) on Price page
M101744 P/L 08.11.04 JH 08/11/04

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/11/04 (12)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

508/11/04 (42)

10.0

POWDER COATING

POWDER COATING



M105642



(12x)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:15
320 °C
3:45

M-H 08/11/04

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-10-04 (42)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

P/L 08/11/04 (12)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/05 JH

mf 08-11-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 41950
Description: Stub Cover		Part Number: D3494-1
Inspection Dwg: D3494	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

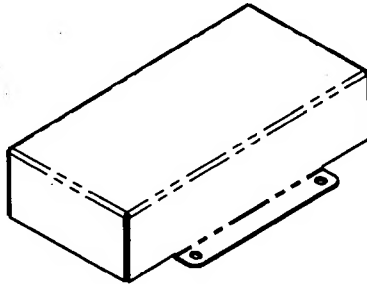
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.208	+/-0.010	.209	*			
0.268	+/-0.010	.270	*			
0.325	+/-0.010	.326	x			
0.723	+/-0.010	.730	x			
2.442	+/-0.010	2.442	x			
2.540	+/-0.010	2.547	x			
6.103	+/-0.010	6.105	x			
6.201	+/-0.010	6.205	x			
7.920	+/-0.010	7.922	x			
8.318	+/-0.010	8.318	x			
8.643	+/-0.010	8.643	x			
1.768	+/-0.010	1.770	x			
1.773	+/-0.010	1.772	x			
3.223	+/-0.010	3.221	x			
3.566	+/-0.010	3.567	x			
7.506	+/-0.010	7.506	x			
7.848	+/-0.010	7.846	x			
9.298	+/-0.010	9.298	x			
9.303	+/-0.010	9.303	x			
11.071	+/-0.010	11.071	x			

Measured by: JB	Audited by: S	Prototype Approval:	N/A
Date: 8-9-11	Date: 08/09/15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	

DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3494	REV. B SHEET 1 OF 2
DATE 06.11.28		TITLE STUB COVER	SCALE 1:2
REV A	DATE 06.01.16	DESCRIPTION NEW ISSUE	
B	06.11.28	REVISED FLAT PATTERN, BENDING DIMENSIONS, Ø0.208 X 0.268 SLOTS WERE Ø0.208 HOLES	

**RELEASED**06.12.05 *PH***UNDER REVIEW**03.01.24 *PH*UPDATE BEND
DIMENSIONS

08.08.11

0.65 Δ B
(TYP, REF)

0.72

PH

06.08.11

4.177

226

447

 Δ B 5.05

REF

PH

08.08.11

4.35

3.75

R0.06
(TYP) Δ B

2.00

1.86

 Δ B

(4 PLACES)

7.63

 Δ B**NOTES:**

- 1) MATERIAL: MAKE FROM D3494-1F
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT PAINT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

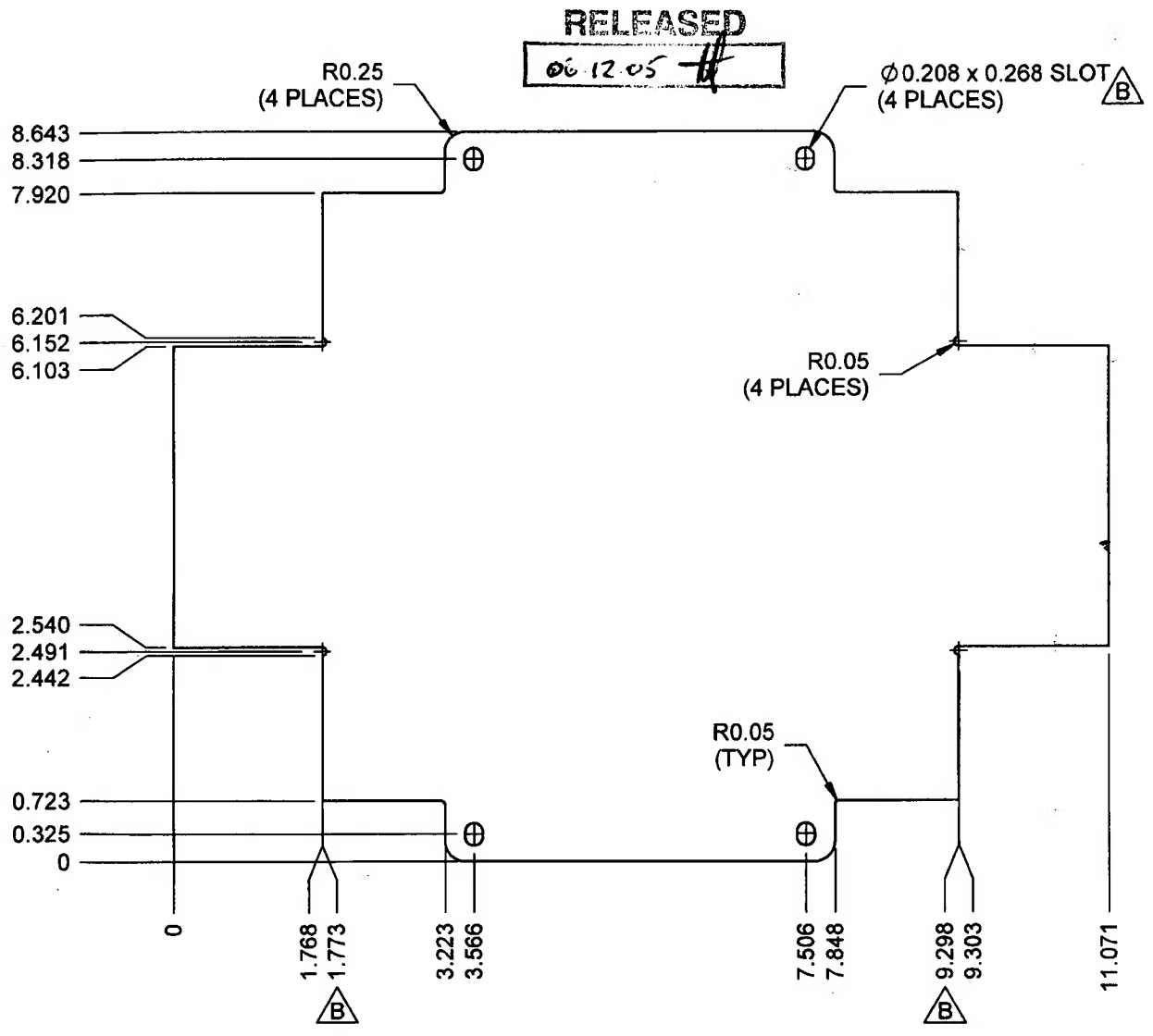
NO. 41956

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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3494	REV. B SHEET 2 OF 2
DATE 06.11.28		TITLE STUB COVER	SCALE 1:2



D3494-1F STUB COVER FLAT PATTERN

UNDER REVIEW

03.01.24 PM
**UPDATE BEND
DIMENSIONS**

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.060 THICK) PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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